

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000892**Date Inspected:** 13-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Arthur Peterson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Plate Trial**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of Orthotropic Box Girder (OBG First Deck Plate Mock-up Weld Trial, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Welding was performed on a 13 meter and 1.7 meter Closed Rib sections. Closed Rib sections were placed on a camber jig prior to welding. QA Inspector Viars monitored welding operations of each section of welding on Gas Metal Arc Welding (GMAW) for the weld root and Submerged Arc Welding for the Cover pass. Semi automatic welding was performed with both processes with a welding head manipulator. Closed rib welds # 1, 2, 5, 6, 9 and 10 were welded simultaneously the full length of each section. Closed rib welds # 3, 4, 7 and 8 were welded in the same manner. Submerged Arc Welding of weld joint # 3, 4, 7 and 8 was performed on swing shift.

Gas Metal Arc Welding of the root pass was performed in accordance to WPS-B-T-2342-U1 (U-ribs). The Submerged Arc Welding was performed in accordance to WPS-B-T-2322-U1 (U-ribs). Amperage of both processes appeared to be within the tolerance of the applicable welding procedure specification.

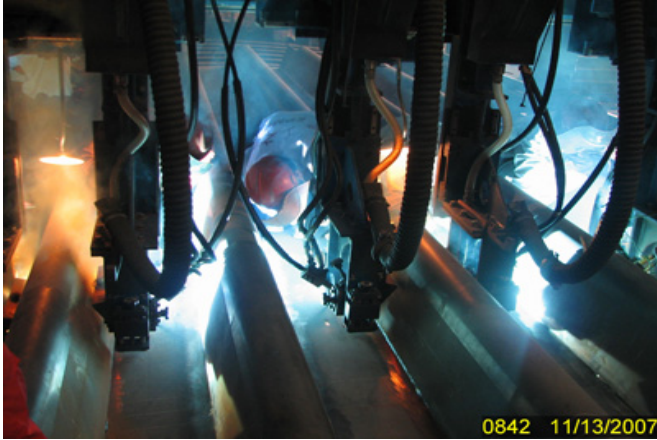
Caltrans QA Inspector monitored welding operations and performed visual observations of the OBG Deck Plate Mock-up Weld Trial.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As identified within the contents of this report.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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